

**Work Order ID 128451****\*128451\***

Page 1

Friday, January 16, 2015 2:37:36 PM

Item ID: D4777-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Rod End Bearing

Start Date: 1/22/15

Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 1/22/15

Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan: MCSDate: 15-01-20

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4777

A

100

0.00

**\*100\***

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 27/99Purchase Part Number: 59915K274 Supplier: Mc Master Carr  
Certificate of conformity is requiredCX 15/01/23 10

110

0.00

**\*110\***

Packaging

Receive &amp; Inspect for Damage &amp; Mat'l Certs

Memo

0.00

Packaging

Ensure certificate of conformity is attached

10x SP 15-01-27

120

0.00

**\*120\***

QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

(10)DAG  
38  
9-89

JAN 27 2015

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                      |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------------|----------------------------------|----------------------------------------|------------------------------------|----------------------------------------------|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>                                                                                                                                                 | Water Jet <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>                                                                                                                                                 | Prod. Eng. Coord. <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>                                                                                                                                                 | Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>                                                                                                                                                 | Supplier <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                      |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |

| Root Cause                             | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|----------------------------------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design <input type="checkbox"/>        |      |      |     |                                                     |                   |                    |             |              |              |
| Doc/Data <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Equip/Tooling <input type="checkbox"/> |      |      |     |                                                     |                   |                    |             |              |              |
| Handling/Pre <input type="checkbox"/>  |      |      |     |                                                     |                   |                    |             |              |              |
| Material <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Operator <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Offset/Setup <input type="checkbox"/>  |      |      |     |                                                     |                   |                    |             |              |              |
| Process <input type="checkbox"/>       |      |      |     |                                                     |                   |                    |             |              |              |
| Supplier <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Training <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Transport <input type="checkbox"/>     |      |      |     |                                                     |                   |                    |             |              |              |
| Unapproved <input type="checkbox"/>    |      |      |     |                                                     |                   |                    |             |              |              |

### FAULT CATEGORY

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

**Work Order ID 128451**

Friday, January 16, 2015 2:37:36 PM

**\*128451\***

Page 2

Item ID: D4777-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Rod End Bearing  
Start Date: 1/22/15 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 1/22/15 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Identify as per dwg & Stock Location: <b>St 127</b> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |                                                     |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                                | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                     |                      |         |        |              |               |               |                  |                |
| 140                            | QC21- Final Inspection - Work Order Release         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |                                                     |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                     |                      |         |        |              |               |               |                  |                |

**10** **15** **JAN 28 2015**

**15-1-28**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>                                                                                                                                                 | Water Jet <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>                                                                                                                                                 | Prod. Eng. Coord. <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>                                                                                                                                                 | Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>                                                                                                                                                 | Supplier <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                      |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |

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| Material <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Operator <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Offset/Setup <input type="checkbox"/>  |      |      |     |                                                     |                   |                    |             |              |              |
| Process <input type="checkbox"/>       |      |      |     |                                                     |                   |                    |             |              |              |
| Supplier <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Training <input type="checkbox"/>      |      |      |     |                                                     |                   |                    |             |              |              |
| Transport <input type="checkbox"/>     |      |      |     |                                                     |                   |                    |             |              |              |
| Unapproved <input type="checkbox"/>    |      |      |     |                                                     |                   |                    |             |              |              |

### FAULT CATEGORY

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
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|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

## Picklist Print

Friday, January 16, 2015 2:37:36 PM

Page 1

**Work Order ID:** 128451

**\*128451\***

**Parent Item:** D4777-1

**\*D4777-1\***

**Parent Item Name:** Rod End Bearing

**Start Date:** 1/22/15

**Required Date:** 1/22/15

**Start Qty: 10.00**

**Required Qty: 10.00**

**Comments:** IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| 59915K274                       |                        | Purchased     | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 10           |               |                |        |
| *59915K274*                     |                        |               |             |                     |                  |                 |                    |                | **          | 10x          | 8/15-01-27    |                |        |
| Rod End Bearing                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

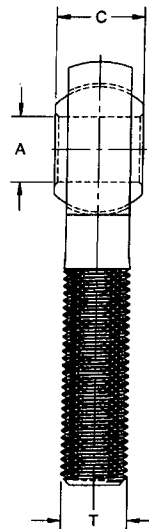
|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------------|----------------------------------|----------------------------------------|------------------------------------|----------------------------------------------|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>                                                                                                                                                 | Water Jet <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>                                                                                                                                                 | Prod. Eng. Coord. <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>                                                                                                                                                 | Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>                                                                                                                                                 | Supplier <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                      |                                    |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design        |      |      |     |                                                     |                   |                    |             |              |              |
| Doc/Data      |      |      |     |                                                     |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |                                                     |                   |                    |             |              |              |
| Handling/Pre  |      |      |     |                                                     |                   |                    |             |              |              |
| Material      |      |      |     |                                                     |                   |                    |             |              |              |
| Operator      |      |      |     |                                                     |                   |                    |             |              |              |
| Offset/Setup  |      |      |     |                                                     |                   |                    |             |              |              |
| Process       |      |      |     |                                                     |                   |                    |             |              |              |
| Supplier      |      |      |     |                                                     |                   |                    |             |              |              |
| Training      |      |      |     |                                                     |                   |                    |             |              |              |
| Transport     |      |      |     |                                                     |                   |                    |             |              |              |
| Unapproved    |      |      |     |                                                     |                   |                    |             |              |              |

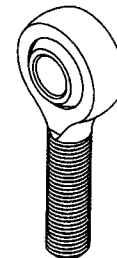
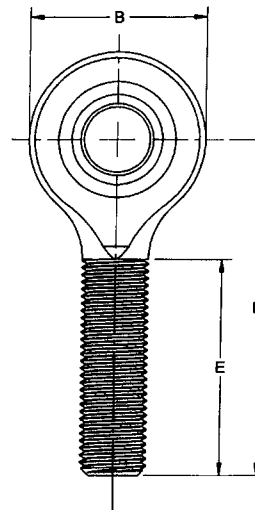
### FAULT CATEGORY

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><br><input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

# SPECIFICATION CONTROL DRAWING



**ROD END BEARING**



STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 128451 - MJS  
15-01-20

| DART P/N | HOUSING MATERIAL | A     | B    | C     | D    | E    | T<br>(THREAD SIZE)  | SUGGESTED SUPPLIER | SUGGESTED SUPPLIER P/N |
|----------|------------------|-------|------|-------|------|------|---------------------|--------------------|------------------------|
| D4777-1  | STAINLESS STEEL  | Ø0.38 | 1.00 | 0.500 | 1.94 | 1.25 | 3/8-24 (RIGHT HAND) | MC MASTER CARR     | 59915K274              |

**RELEASED**  
2013-08-14  
WP

|            |             |     |          |
|------------|-------------|-----|----------|
| A          | NEW ISSUE   | AJS | 13.08.08 |
| REV.       | DESCRIPTION | BY  | DATE     |
| DESIGN     | AJS         |     |          |
| DRAWN      | AJS         |     |          |
| CHECKED    |             |     |          |
| MFG. APPR. |             |     |          |
| APPROVED   |             |     |          |
| DE APPR.   |             |     |          |
| DATE       | 13.08.08    |     |          |

|                                                                                                                                                                                                                                                               |                        |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                      |                        |
| DRAWING NO.<br><b>D4777</b>                                                                                                                                                                                                                                   | REV. A<br>SHEET 1 OF 1 |
| TITLE<br><b>ROD END BEARING</b>                                                                                                                                                                                                                               | SCALE<br>NTS           |
| COPYRIGHT © 2013 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |                        |

ACE

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

**PURCHASE ORDER****Purchase Order ID PO27199****Purchase Order Date** 1/23/2015**PO Print Date** 1/23/2015**Page Number** 3 of 4**Order From :**

VU-MCM001

**Ship To :** DART AEROSPACE LTD

MCMASTER-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name****Vendor Phone** 330 995 5500**Ship To Contact****Ship To Phone****Ship Via:** Purolator ground ppd**Ship Acct:****Buyer**

Chantal Lavoie

**Customer POID****Customer Tax #** 10127-2607**Terms**

Net 10

**Currency**

USD

**FOB**

FCA - (Free Carrier)

**Line Total:** \$13.32

59915K274

Rod End Bearing

1/27/2015

Yes

1/27/2015

10.00 ✓

Each

\$17.14

\$171.40

AS PER DWG D4777 REV. A  
B128451

8015-01-27

**Line Total:** \$171.40

92311A564

Set Screw

1/27/2015

Yes

1/27/2015

50.00

Each

\$0.24

\$11.87

AS PFWR DWG D3533 REV. B  
B128448

**Line Total:** \$11.87

98470A133

Pin, Quick Release

1/27/2015

Yes

1/27/2015

12.00

Each

\$3.01

\$36.12

AS PER DWG D4811 REV. A  
B128694

**Note:**

1/23/2015



200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Purchase Order  
**PO27199**

Order Placed By  
**Chantal Lavoie**

McMaster-Carr Number  
**6331715-01**

Page 1 of 1

01/23/2015

| Line | Product                                                                                                                                              | Ordered    | Shipped |
|------|------------------------------------------------------------------------------------------------------------------------------------------------------|------------|---------|
| 1    | <b>7494T86</b> Shop-Vac Vacuum Accessory, Plastic Reducer 2-1/2" Diameter X 1-1/4" Diameter<br>Your Part Number: <b>71400-20</b>                     | 2<br>Each  | 2       |
| 2    | <b>9452K54</b> Oil-Resistant Buna-N Multipurpose O-Ring, 3/16 Fractional Width, Dash Number 334,<br>Packs of 50<br>Your Part Number: <b>71500-30</b> | 1<br>Pack  | 1       |
| 3    | <b>8647A42</b> Mitutoyo Standard Electronic Caliper, 500-196-30, 0-6" (0-150MM) Range<br>Your Part Number: <b>71500-65</b>                           | 1<br>Each  | 1       |
| 4    | <b>8647A32</b> Mitutoyo Standard Electronic Caliper, 500-193, 0-12" (0-300MM) Range<br>Your Part Number: <b>71500-65</b>                             | 1<br>Each  | 1       |
| 5    | <b>6718K52</b> Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling<br>Size                                          | 4<br>Each  | 4       |
| 6    | <b>91525A120</b> Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000"<br>OD, Packs of 25                              | 2<br>Packs | 2       |
| 7    | <b>59915K274</b> PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball<br>ID, 1-1/4" L Thread                      | 10<br>Each | 10      |
| 8    | <b>92311A564</b> 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50                                                      | 1<br>Pack  | 1       |
| 9    | <b>98470A133</b> 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3"<br>Usable Length                              | 12<br>Each | 12      |

2015-01-27

McMaster-Carr Supply Company  
200 Aurora Industrial Pkwy  
Aurora, OH 44202-8087 USA  
Phone: 330-995-5500 Fax: 330-995-9600  
E-Mail: cle.sales@mcmaster.com  
Employer Identification Number (EIN): 36-1458720

Invoice: 21385304  
Purchase Order: PO27199  
Release:  
McMaster-Carr Number: 6331715-01

ORIGINAL COMMERCIAL  
**INVOICE**  
CERTIFICATE OF ORIGIN

Ultimate Destination:  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Shipped: 23-Jan-2015 FOB: ORIGIN  
Shipper's Export Declaration (SED):  
NO EEI 30.36

Intermediate Consignee:

Bill To:  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Tax Number:

Forwarding Agent:

Billing  
Attention:

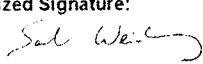
Shipping  
Attention:

Contact:

| Line                                                                                                                                                                              | Description                                                                                                                                                                                                    | Qty & Unit | Unit Price | Extension |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|------------|-----------|
| 1                                                                                                                                                                                 | 7494T86 Shop-Vac Vacuum Accessory, Plastic Reducer 2-1/2" Diameter X 1-1/4" Diameter<br>71400-20<br>Country of Origin: United States<br>Schedule B #: 391740<br>ECCN #: EAR99 NLR                              | 2 EA       | \$7.59     | \$15.18   |
| 2                                                                                                                                                                                 | 9452K54 Oil-Resistant Buna-N Multipurpose O-Ring, 3/16 Fractional Width, Dash Number 334, Packs of 50<br>71500-30<br>Country of Origin: Peoples Republic of China<br>Schedule B #: 401693<br>ECCN #: EAR99 NLR | 1 PK       | \$12.56    | \$12.56   |
| 3                                                                                                                                                                                 | 8647A42 Mitutoyo Standard Electronic Caliper, 500-196-30, 0-6" (0-150MM) Range<br>71500-65<br>Country of Origin: Japan<br>Schedule B #: 901730<br>ECCN #: EAR99 NLR                                            | 1 EA       | \$132.59   | \$132.59  |
| 4                                                                                                                                                                                 | 8647A32 Mitutoyo Standard Electronic Caliper, 500-193, 0-12" (0-300MM) Range<br>71500-65<br>Country of Origin: Japan<br>Schedule B #: 901730<br>ECCN #: EAR99 NLR                                              | 1 EA       | \$392.76   | \$392.76  |
| 5                                                                                                                                                                                 | 6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size<br><br>Country of Origin: United States<br>Schedule B #: 848190<br>ECCN #: 2B999 NLR                         | 4 EA       | \$5.88     | \$23.52   |
| Your order is subject only to our terms and conditions, available at <a href="http://www.mcmaster.com">www.mcmaster.com</a> or from our Sales Department.                         |                                                                                                                                                                                                                |            |            |           |
| These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited. |                                                                                                                                                                                                                |            |            |           |

|                                                       |                       |                 |                              |
|-------------------------------------------------------|-----------------------|-----------------|------------------------------|
| Shipping Weight (in kgs): 4                           | Number of Packages: 1 | Invoice Amounts | Merchandise Amount: \$809.32 |
| Package Dimensions:<br>15 X 46 X 20 CM = .014 CUBIC M |                       |                 | Canadian GST/HST: \$106.95   |
|                                                       |                       |                 | Shipping Charges: \$13.40    |
|                                                       |                       |                 | Total (In USD): \$929.67     |

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Authorized Signature:   
Name: Sarah Weinberg  
Title: Operations Mgr.

Date: 23-Jan-2015

Remit payment to:  
(by mail)  
McMaster-Carr Supply Company  
PO Box 7690  
Chicago, IL 60680-7690 USA  
(by wire transfer)  
Bank of America Illinois  
231 S LaSalle  
Chicago, IL 60697  
ABA 071000039 Account 86666-02021  
SWIFT BOFAUS3N

McMaster-Carr Supply Company  
 200 Aurora Industrial Pkwy  
 Aurora, OH 44202-8087 USA  
 Phone: 330-995-5500 Fax: 330-995-9600  
 E-Mail: cle.sales@mcmaster.com  
 Employer Identification Number (EIN): 36-1458720

Invoice: 21385304  
 Purchase Order: PO27199  
 Release:  
 McMaster-Carr Number: 6331715-01

ORIGINAL COMMERCIAL

# INVOICE

CERTIFICATE OF ORIGIN

| Line                                                       | Description                                                                                                                                                                                                | Qty & Unit | Unit Price | Extension |
|------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|------------|-----------|
| 6                                                          | 91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25<br><br>Country of Origin: Taiwan<br>Schedule B #: 731822<br>ECCN #: EAR99 NLR                | 2 PK       | \$6.66     | \$13.32   |
| 7                                                          | 59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread<br><br>Country of Origin: United States<br>Schedule B #: 848330<br>ECCN #: EAR99 NLR | 10 EA      | \$17.14    | \$171.40  |
| 8                                                          | 92311A564 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50<br><br>Country of Origin: Taiwan<br>Schedule B #: 731815<br>ECCN #: EAR99 NLR                                     | 1 PK       | \$11.87    | \$11.87   |
| 9                                                          | 98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length<br><br>Country of Origin: United States<br>Schedule B #: 731829<br>ECCN #: EAR99 NLR         | 12 EA      | \$3.01     | \$36.12   |
| NOTE Tracking number(s) for this shipment:<br>MFA004037822 |                                                                                                                                                                                                            |            |            |           |

SP15-01-27

Number of Packages: 1

Page 2 of 2